

Work Order ID 57248

March 31, 2010 10:03:17 AM



Page 1

Item ID: D5955

Accept

Revision ID:

Item Name: Saddle, 205

Setup

Start



Start Date: 31/03/2010 Start Qty: 4.00



Required Date: 09/04/2010 Req'd Qty: 4.00



Cust Item ID:
Customer:

Stop



Reference:

Approvals: Process Plan: *PL* Date: *10-3-31* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D5955	Rev B

100	0.00
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HAAS 1	HAAS CNC VERTICAL MACHINING #1
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HAAS 1	Memo	0.00
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HAAS CNC vertical machine #1
1-Machine as per folio D5955, Ensure Batch Number is entered 2-Machine
Keyway 3-Deburr & Tumble

110	QC1- Inspect dimensions to dimension sheet	0.00
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QC	Memo	0.00
----	------	------

Quality Control

120	QC8- Inspect parts - second check	0.00
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QC	Memo	0.00
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Quality Control

B.A 10/04/07

4 Ø

B.A 10/04/07

4 Ø

*MW
10/04/07*

4 Ø

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 57248

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Item ID: D5955

Accept



Setup

Start



Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00



Required Date: 09/04/2010 Req'd Qty: 4.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours
0.00Draw
Number
0.00Draw
Rev.Plan
CodeAccept
Qty
0.00Reject
Qty
0.00Reject
Number
0.00Insp.
Stamp
0.00

=741 10/04/08

X4 φ

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

0.00

=741 10/04/08

X4 φ

Memo

0.00

START TIME:

11:45am

OVEN TEMPERATURE:

12:15pm

320°F

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10-4-8.

④ φ

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 57248

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Item ID: D5955

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 31/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

160

Operation
Description

Identify as per dwg & Stock Location: 430

Set Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

0.00

Parry/84

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/04/12 AF**MF
10-4-9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:03:21 AM

Page 1

Work Order ID: 57248

Parent Item: D5955

Parent Item Name: Saddle, 205



Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Start Date: 31/03/2010

Start Qty: 4.00

Required Date: 09/04/2010

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-013 Saddle Billet		Manufactured	No			100	Each	28.0000	4.0000			

Warehouse
Location

Main Warehouse

MAT47

Loc Qty

46413

Loc Code

28
28

4.0

H.A 10/04/07

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DART AEROSPACE LTD				Work Order:	
Description: Outer Aft Saddle		Part Number:		D5955	
Inspection Dwg: D5955		Rev: B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441	0.441	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.499	0.499	0.499	0.499		
N	1.865	1.885		1.880	1.885	1.880	1.881		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.256	2.257	2.258	2.258		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.763	0.763	0.763	0.763		
S	0.490	0.510		0.500	0.498	0.497	0.500		
T	1.625	1.645		1.632	1.635	1.635	1.636		
U	2.000	2.020		2.005	2.006	2.007	2.007		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	H.A	Audited by:	MU
Date:	10/04/07	Date:	10/04/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	DA

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